



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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646.4001

Job Sheet 196012



Part No: 646.4001

Job Qty: 1 pcs

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/4/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/2/19

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		7/2/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		Oscar
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

Dart Aerospace Ltd.
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Container No: S211185

Part: 646.4001

Job No: 196012

Serial No/Batch: S211185

Revision:

Inspector:

Exp Date: 02/01/2020

Instructions: FAA STC SR02180LA 14/02/2019 JAL/STC SH09 -

Plex 6/4/19 3:02 PM Dart.lajeunesse.marie

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					QC 4 - 28	
					QC 4 - 58	
120 QC 4	1 pcs	7/2/19	0.00 0.00		QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
130 Packaging 3-1 - Stock - B4B	1 pcs	7/2/19	0.00 0.00		Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	7/2/19	0.00 0.00		DC - 1 - B4B	
					DC - 2 - B4B	
140 QC 21 - FG	1 pcs	7/2/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

DAS
58 SEP 17 2019DAS
58 SEP 17 2019DAS
21 SEP 17 2019DAS
21 SEP 17 2019

Part Op 110 - pick kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify and pack for shipping as per PPP 646.4001 Location: F9100

135 - Document Control - Photocopy bluefile & type labels per PPP 646.4001

140 - QC21- Final Inspection - Work Order Release

Master Unit No 011466

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	110-Packaging 1 - Pick Kit	5158240 ✓
600.0990 03/31/2020	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	5182078 ✓
600.0991 03/31/2020	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	5182079 ✓
600.1012 11/30/2019	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5166686 ✓
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea) ✓	110-Packaging 1 - Pick Kit	5166242 ✓
646.2910	Deflector	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5195161 ✓
646.3001	Lower Cable Cutter Assembly	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5203920 ✓
646.3110	Channel	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5192731 ✓
646.3210	Support	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5177298 ✓
646.3301	Upper Cutter Assembly	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5208586 ✓
646.3510	Strut	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5187754 ✓
646.3511	Strut	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5183035 ✓
646.3610	Filler	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5172257 ✓
646.3710	Doubler	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5059684 ✓
646.3711	Clip	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5183057 ✓
646.3712	Clip	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5183061 ✓
646.3713	Gusset	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5190438 ✓
646.3714	Gusset	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5197814 ✓
646.3715	Strut Doubler	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5190143 ✓
646.3716	Gauge Bracket	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5172198 ✓
646.3717	Doubler	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5190396 ✓
646.3718	Custom Washer	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5202529 ✓
646.3719	Doubler	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5202485 ✓
646.3810	Bracket	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5190891 ✓
646.3811	Radius Block	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5196092 ✓
646.3812	Gusset Bracket	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5189359 ✓
646.3813	AS350 Strut Bracket	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5189353 ✓
646.3910	Shim	4 pcs (4 ea) ✓	110-Packaging 1 - Pick Kit	5185679 (12) ✓ 20852K2
646.3911	Shim	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5133609 ✓
646.3912	Shim	4 pcs (4 ea) ✓	110-Packaging 1 - Pick Kit	5181461 ✓
646.3913	Shim	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5185683 ✓
646.9410	Shim	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5056998 ✓
647.0112	Strut Bracket	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5162314 ✓
647.7703	Strut Assembly	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5187902 ✓
650.9201	Eyelet Bracket Assembly	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5175957 ✓
AN3-11A	Bolt	10 Ea (10 ea) ✓	110-Packaging 1 - Pick Kit	5149267 ✓
AN3-12A	Bolt	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5166926 ✓
AN3-13A	Bolt	1 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	5098032 ✓
AN3-3A	Bolt	4 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5192148 ✓
AN3-4A	Bolt	10 Ea (10 ea) ✓	110-Packaging 1 - Pick Kit	5167263 ✓
AN3-5A	Bolt	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5149158 ✓
AN3-6A	Bolt	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5149185 ✓
AN316C4R	Nut, Jam	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5180977 ✓
AN44-5A	Eyebolt	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5192383 ✓
AN4C7A	Bolt	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5190028 ✓
AN665-34R	Clevis	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5190007 ✓
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea) ✓	110-Packaging 1 - Pick Kit	5156961 ✓
CR3213-5-3	Cherry Rivet	14 Ea (14 ea) ✓	110-Packaging 1 - Pick Kit	5185286 ✓
MS20426AD5-7	Rivet	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	51133922-36 ✓
MS20470AD5-5-5	Rivet	8 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	5155675 ✓
MS20470AD5-6	Rivet	8 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	5046892 ✓
MS20470AD5-7	Rivet	3 Ea (3 ea) ✓	110-Packaging 1 - Pick Kit	5203251 ✓
MS21042L08	Nut	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5193124 ✓
MS21042L3	Nut	63 Ea (63 ea) ✓	110-Packaging 1 - Pick Kit	5204283 ✓
MS21042L4	Nut	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5192444 ✓
MS21047-3	Nut Plate	18 Ea (18 ea) ✓	110-Packaging 1 - Pick Kit	5162656 ✓
MS24693-C278	Screw	5 Ea (5 ea) ✓	110-Packaging 1 - Pick Kit	5157611 ✓
MS24694-S51	Screw	5 Ea (5 ea) ✓	110-Packaging 1 - Pick Kit	5133343 ✓
MS24694-S54	Screw	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5185070 ✓

MS24694-S55	Screw
MS27039-08-13	Screw
MS27039-1-10	Screw
MS27039-1-12	Screw
MS27039-1-16	Screw
MS27039-1-19	Screw
MS27039-1-20	Screw
MS27039-1-21	Screw
NAS1149F0332P	Washer
NAS1149F0363P	Washer
NAS1149F0432P	Washer
NAS1149FN832P	Washer

3 Ea (3 ea) ✓	110-Packaging 1 - Pick Kit
2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit
2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit
6 Ea (6 ea) ✓	110-Packaging 1 - Pick Kit
24 Ea (24 ea) ✓	110-Packaging 1 - Pick Kit
22 Ea (22 ea) ✓	110-Packaging 1 - Pick Kit
2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit
4 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit
144 Ea (144 ea) ✓	110-Packaging 1 - Pick Kit
2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit
4 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit
4 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit

5142492 ✓
3123937 ✓
5157316 ✓
5174154 ✓
5157063 ✓
5156890 ✓
5182772 ✓
5167939 ✓
5167109 ✓
5075330 ✓
5155666 ✓
5191300 ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0129	8	128	0
	600.0990	1	15	0
	600.0991	1	15	0
	600.1012	1	21	0
	600.1013	5	101	0
	646.2910	1	12	0
	646.3001	1	6	0
	646.3110	1	9	0
	646.3210	1	21	0
	646.3301	1	0	0
	646.3510	1	5	0
	646.3511	1	32	0
	646.3610	1	25	0
	646.3710	1	13	0
	646.3711	1	25	0
	646.3712	1	28	0
	646.3713	1	7	0
	646.3714	1	6	0
	646.3715	2	13	0
	646.3716	1	20	0
	646.3717	1	6	0
	646.3718	2	13	0
	646.3719	2	12	0
	646.3810	2	21	0
	646.3811	1	2	0
	646.3812	2	14	0
	646.3813	1	21	0
	646.3910	4	43	0
	646.3911	1	29	0
	646.3912	4	40	0
	646.3913	1	26	0
	646.9410	1	62	0
	647.0112	2	41	0
	647.7703	2	10	0
	650.9201	2	33	0
	AN3-11A	10	207	0
	AN3-12A	2	231	0
	AN3-13A	1	24	0
	AN3-3A	4	190	0
	AN3-4A	10	554	0
	AN3-5A	2	180	0
	AN3-6A	2	250	0
	AN316C4R	2	27	0
	AN44-5A	2	31	0
	AN4C7A	2	99	0
	AN665-34R	2	18	0
	CCR264SS3-02	36	516	0
	CR3213-5-3	14	187	0
	MS20426AD5-7	2	809	0
	MS20470AD5-5-5	8	857	0
	MS20470AD5-6	8	725	0
	MS20470AD5-7	3	37	0
	MS21042L08	2	500	0
	MS21042L3	63	1,860	0

MS21042L4	2	2,120	0
MS21047-3	18	221	0
MS24693-C278	5	56	0
MS24694-S51	5	312	0
MS24694-S54	2	266	0
MS24694-S55	3	234	0
MS27039-08-13	2	402	0
MS27039-1-10	2	341	0
MS27039-1-12	6	134	0
MS27039-1-16	24	884	0
MS27039-1-19	22	465	0
MS27039-1-20	2	90	0
MS27039-1-21	4	163	0
NAS1149F0332P	144	3,221	0
NAS1149F0363P	2	395	0
NAS1149F0432P	4	1,618	0
NAS1149FN832P	4	1,620	0

Part Specifications

Specifications could not be found.

Plex 6/4/19 3:02 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Cross tube ☐ ☐ Eng. (Non-AW) ☐ ☐ Small Fab ☐ ☐ Prod. Eng. Coord. ☐ ☐ Finishing ☐ ☐ Rec/Store/Packaging ☐ ☐ Skid-tube ☐ ☐ Machining ☐ ☐ Large Fab ☐ ☐		Engineering ☐ ☐ Water Jet ☐ ☐ Supplier ☐ ☐ Quality ☐ ☐																									
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042) _____																									
Description Work Order Deviation				Disposition																											
Root Cause Operator ☐ ☐ Manufacturing Process ☐ ☐ Equip/Tooling ☐ ☐ Handling/Preservation ☐ ☐ Material ☐ ☐ Product Improvement ☐ ☐ Process Improvement ☐ ☐ Human Factors ☐ ☐				FAULT CATEGORY																											
				<table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread
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Cracks	Broken/Damage/Defect	Weld	Finish																												
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Marks/Chatter	Drill Holes	Out of Sequence	Misread																												
Mislabeled	Fit/Function	Off-set/Set-up																													
Other/Details: _____				Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																											

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[illegible]